

Date: Thursday, 04/09/2008 1:25:22 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD TUBE ASSEMBLY
Job Number : 41841	
Estimate Number : 10467	
P.O. Number :	Part Number : D3391021
This Issue : 04/09/2008 S.O. No. :	Drawing Number : D3391 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : G
Previous Run : 41840	Material :
Written By :	Due Date : 25/09/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUL 08.9.04</u>	
Comment : Est. A 05.09.13 New issue KJ/JLM Est. B 06.02.10 Dwg rev.D ecn 773 EC Est. C 06.05.02 Added inspections EC est D 07.03.13 rev F dwg EC est E 07.11.07 revG dwg ecn1053P EC verified by: DD Est Rev:f ECN 1056 07-11-12 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6013047	Skidtube Material
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	<u>26547</u>

RT 08-09-05

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1
Cut extrusion to 46.52 +0.010 -0.020

RT 08-09-05

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: Nc bender
Bend as per Dwg D3391 Using Bend Prog 3391021

RT 08-09-05

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/05 @

H:\FORMS\Quality Assurance\appt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:25:22 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41841

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. F & Dwg D3391 Rev. G

Identify as D3391-1

2-Deburr

J.L 08/09/07

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/09/07

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391 .1875" dia

mmf 08/09/11

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/09/11

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08-09-11

(1)

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr & Scribe Batch number Inside aft end.

6-Transfer drill D3391-021 with D3391-023

JP 8-9-22

11
29-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41841

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/09/22 @

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Jb 8-9-22

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① 11-9-22

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch:

B41625

④ 11-9-22

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch: M108966

exp. date: 02/08/2009-10-1

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

11-9-22

11-9-23

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

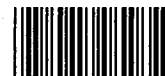
17.0

POWDER COATING

POWDER COATING



M108523



①X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

8-15 OF
320

M-1 08/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:25:22 PM
User: Julie Lecocq

Process Sheet

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41841

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

FINISH TIME:

8:45

M-1

08/04/29 (10)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/09/25 (1)

19.0

ALS41032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

batch:

m105819.

or equivalent

per QSI 017

FL.

20.0

ALS41032225

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

INSERT

batch:

m100621

or equivalent

per QSI 017

FL.

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

FL 08/09/25 (1)

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/25 (10)

23.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

D36216

FL 08/09/25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41841

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE

641335

FL

25.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET

641862

FL

26.0

D36721

Phenolic Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
PHENOLIC WASHER

639275

FL

27.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN3C4A

Bolt

m/09061

FL

28.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)
washer

m/08928

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Install tow Cap as per Dwg D3391
Identify as D3391-021

FL 08/09/25 (1)

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect thread of each insert using DT8821

S 08/09/09 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41841

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 41691 Pcs 8/9/28 C

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30 J

Job Completion



mf 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41841
Description: Float Skidtube (412)		Part Number: D3391-1
Inspection Dwg: D3391	Rev: G	Page 1 of 1

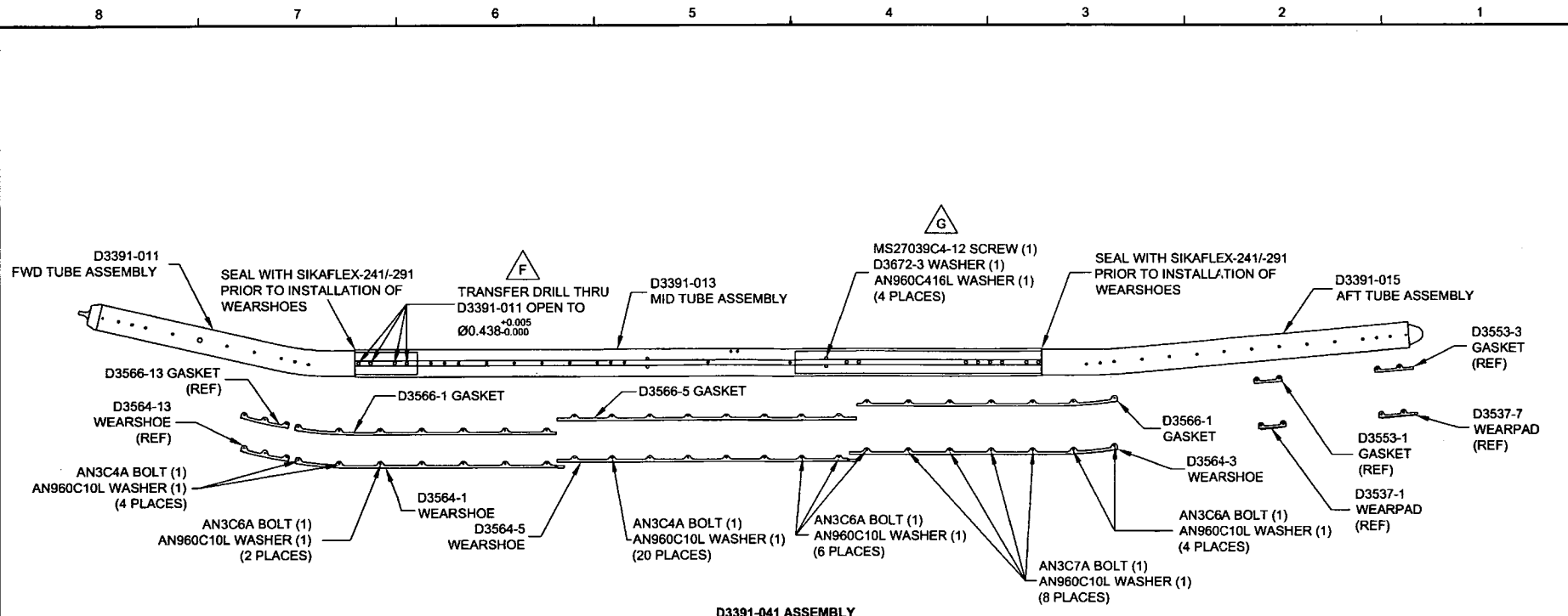
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+0.010/-0.000	0.694	/			
3.590	+0.025/-0.010	3.604	/			
3.300	+0.040/-0.000	3.320	/			
1.429	+0.040/-0.060	1.420	/			
4.250	+/-0.010	4.250	/			
4.250	+/-0.010	4.250	/			

Measured by: J.L.	Audited by: [Signature]	Prototype Approval: N/A
Date: 08/09/07	Date: 08.09.11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
B	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
C	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
D	07.11.23	Dwg Rev. updated	KJ/EC/DD	[Signature]



D3391-041 ASSEMBLY

RELEASED
27-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
2	AN3C7A	BOLT
1	AN960C10L	WASHER
1	MS27039C4-12	SCREW
1	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

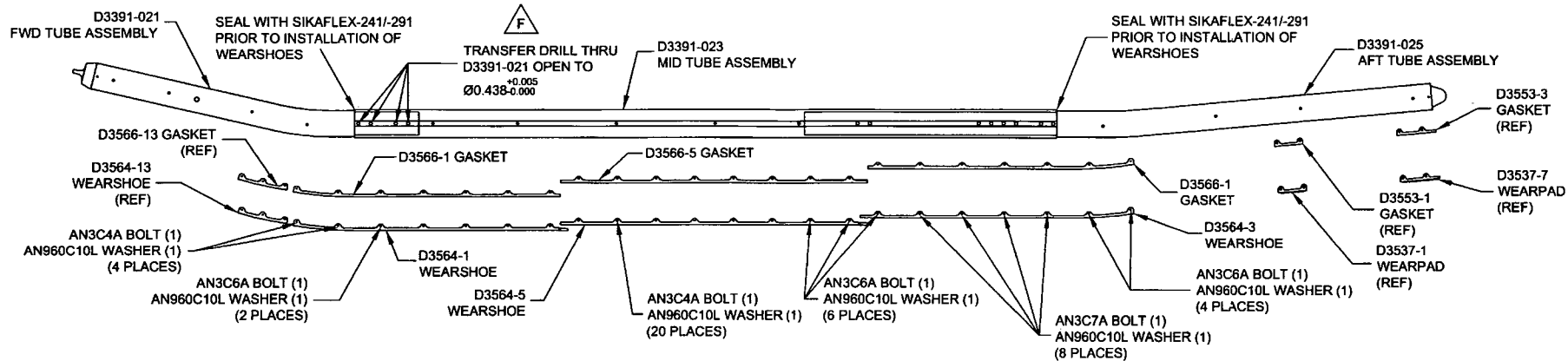
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWJ SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3391 REV. G
SHEET 1 OF 8
TITLE 412 FLOAT SKIDTUBE
SCALE NTS

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WORK ORDER
NO. 41847
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RELEASED
07.11.97

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

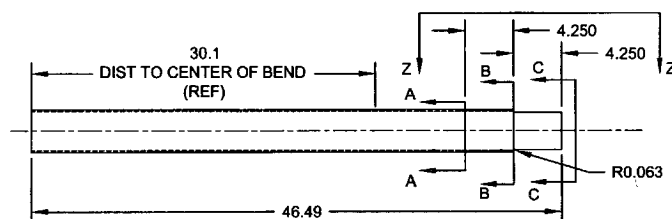
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-3	GASKET
28	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

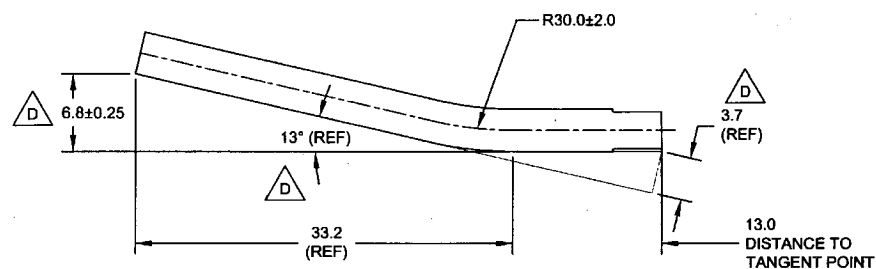
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	JLC	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. G
MFG. APPR.	J	D3391	SHEET 2 OF 8
APPROVED	J	TITLE	SCALE
DE APPR.	J	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

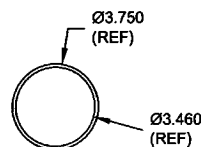
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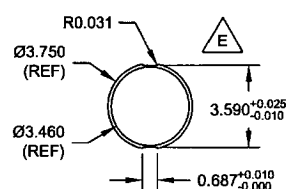
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



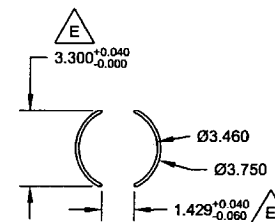
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



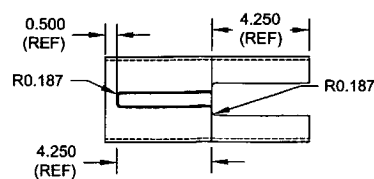
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(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)

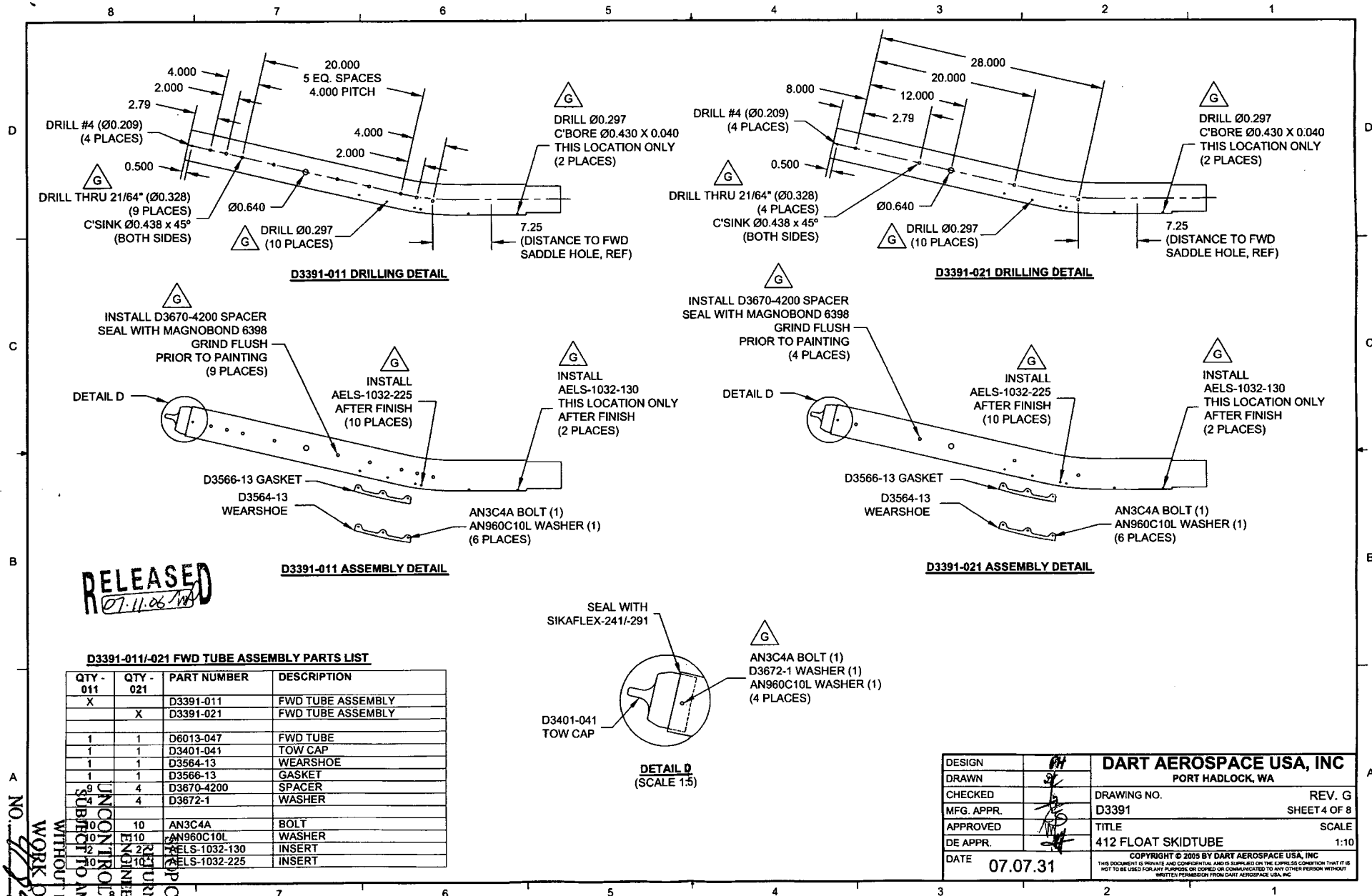


VIEW Z-Z
(SCALE 1:5)

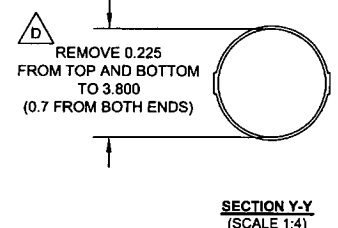
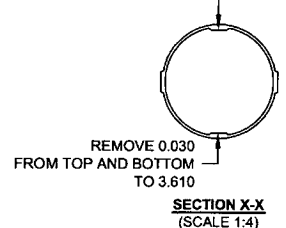
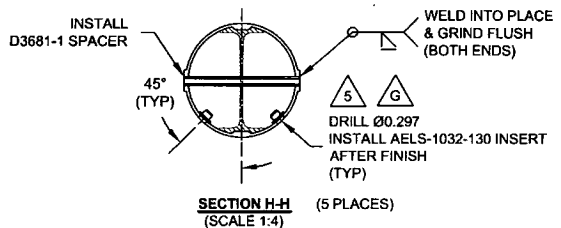
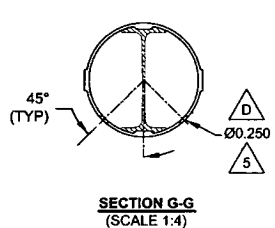
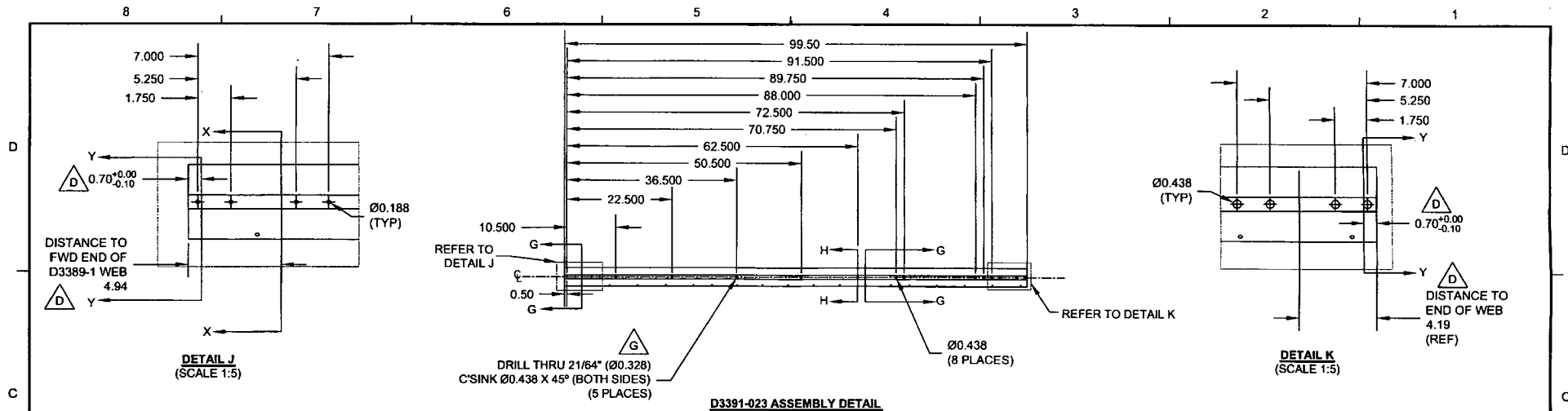
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NO. 11021
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DESIGN	412	DART AEROSPACE USA, INC	
DRAWN	412	PORT HADLOCK, WA	
CHECKED	412	DRAWING NO.	REV. G
MFG. APPR.	412	D3391	SHEET 3 OF 8
APPROVED	412	TITLE	SCALE
DE APPR.	412	412 FLOAT SKIDTUBE	1:10
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	







D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

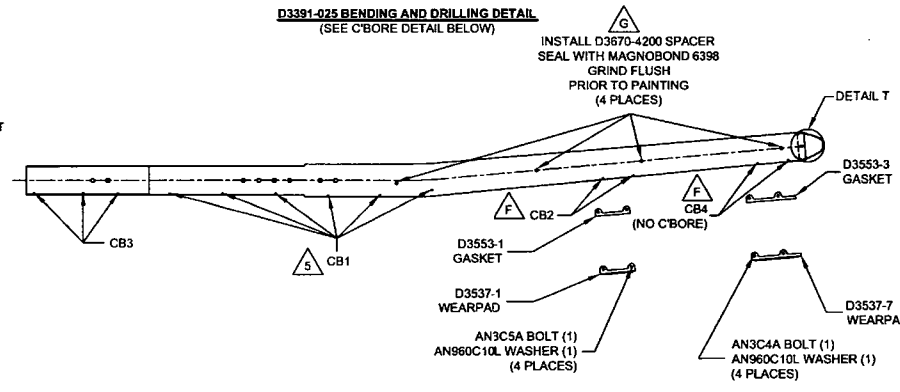
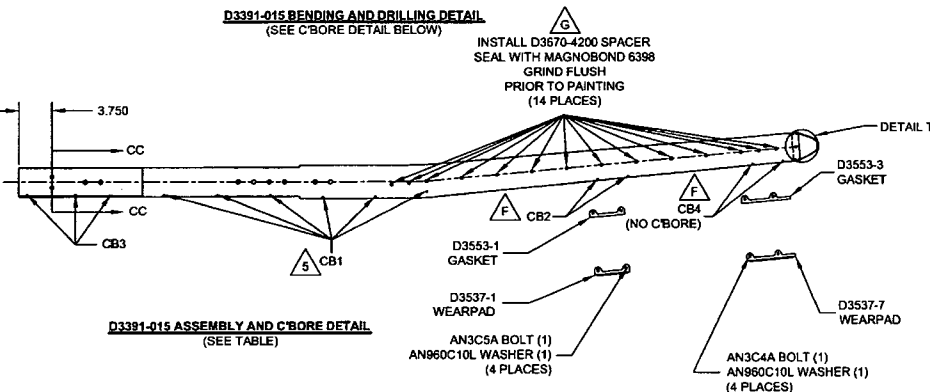
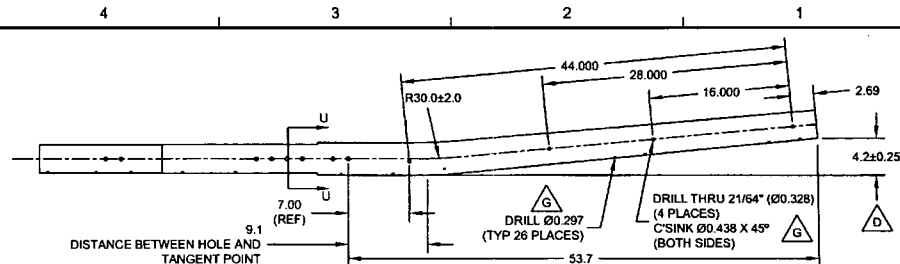
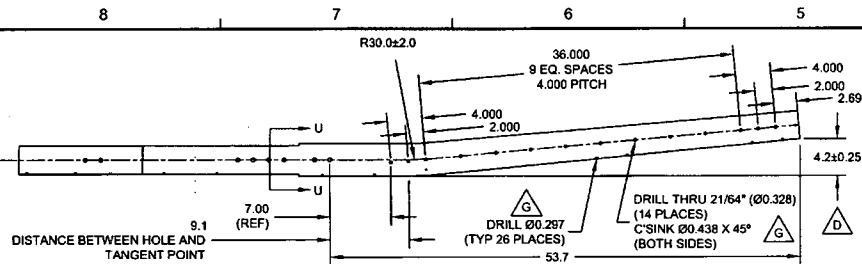
D3391-023 MID TUBE ASSEMBLY

MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 WELDING: PER DART QSI 004

RELEASED
 07.11.06/14

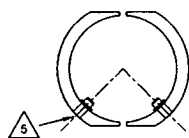
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	DE	PORT HADLOCK, WA	
CHECKED	h	DRAWING NO.	REV. G
MFG. APPR.	ED	D3391	SHEET 6 OF 8
APPROVED	W	TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:20
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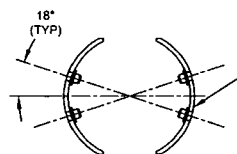


D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

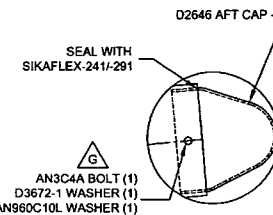


SECTION U-U
(SCALE 1:3)



SECTION CC-CC
(SCALE 1:3)

DRILL Ø.391
C'BORE Ø.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)



DETAIL T
(SCALE 1:3)

RELEASED
07-11-06

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø.430 X 0.170	AELS-1032-225
CB2	4	4	Ø.430 X 0.170	AELS-1032-130
CB3	6	6	Ø.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC
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CHECKED	JS	DRAWING NO. REV. G
MFG. APPR.	JS	D3391 SHEET 8 OF 8
APPROVED	JS	TITLE SCALE
DE APPR.	JS	412 FLOAT SKIDTUBE 1:12
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